

Date:
User:Tuesday, 1/3/2006 4:20:19 PM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number :	25376	Part Number :	D29331
Estimate Number :	10833	Drawing Number :	D2933 REV B
P.O. Number :	N/A	Project Number :	N/A
This Issue :	1/3/2006	Drawing Revision :	B
Prsht Rev. :	NC	Material :	N/A
First Issue :	N/A	Due Date :	1/30/2006
Previous Run :	25147	Qty:	6 Um: Each
Written By :	SEE COMMENT BELOW		
Checked & Approved By :	SEE ABOVE USER & DATE		
Comment :	Est: B00.06.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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06.03.12

4089 clean?

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B24890

En 06/01/15

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number. En 06/01/15

1-Inspect part number and batch number are programmed correctly. - SD 06.01.15

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

En/36 06.01.16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD 06.04.13

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

SD 06.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		2.1.1.000 As					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 25376

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JK 06/04/17

6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-04-18

6

7.0

POWDER COATING

POWDER COATING.



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-18

6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/4/19 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST475*

SP 06/04/19 6

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/20 (6)

Job Completion



a 06-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25376
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.115	.120	.120	.120		
B	0.100	0.140		0.122	.121	.122	.122		
C	0.100	0.140		0.128	.130	.128	.128		
D	0.210	0.230		0.215	.210	.215	.215		
E	1.245	1.255		1.247	1.250	1.250	1.250		
F	1.245	1.255		1.247	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.515	.515	.515	.515		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.498	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		.239	.238	.238	.238		
N	0.100	0.140		0.123	.118	.120	.120		
O	0.540	0.560		0.544	.545	.545	.548		
P	0.490	0.510		0.503	.503	.503	.503		
Q	3.715	3.725		3.719	3.717	3.718	3.718		
R	2.470	2.510		2.500	2.492	2.492	2.492		
S	0.240	0.270		0.249	.247	.248	.248		
T	0.100	0.180		0.146	.145	.145	.145		
U	1.625	1.635		1.631	1.631	1.631	1.631		
V	1.362	1.372		1.366	1.365	1.365	1.365		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.134	1.135	1.136	1.136		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JN / 36 1 SA	Audited by: [Signature]
Date: 06.01.16 06.04.13	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

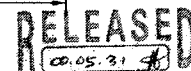
DART AEROSPACE LTD	Work Order:	25376
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:






				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120				
B	0.100	0.140		.118	.120				
C	0.100	0.140		.125	.124				
D	0.210	0.230		.215	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.515	.515				
I	1.572	1.582		1.577	1.576				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262	DT8683	0.257	0.257				
L	0.312	0.317	DT8686	0.312	0.312				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.120	.125				
O	0.540	0.560		.548	.546				
P	0.490	0.510		.503	.502				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.142	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	0.320	0.326				
X	1.125	1.145		1.135	1.135				
Y	1.565	1.585	DT8695 A/B	✓	✓				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: BG / SA	Audited by:
Date: 06.01.16 06.04.13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	



NO. 25376

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN 	DRAWN BY RT 	 DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED 	APPROVED 	
DATE 00.05.29		DRAWING NO. D2933 TITLE: SADDLE INSIDE REV. 1 OF 1 SHEET 1 OF 1 SCALE: 2:1

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